

Work Order ID 127525

127525

Page 1

December-17-14 1:36:24 PM

Item ID: D3053-042 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: 212 Basket Base Assembly
 Start Date: 1/06/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 1/06/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: ML5 Date: 11-12-22 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3053	C

100 Large Fab 0.00
100
 Large Fab Memo 0.00
 Large Fab 1-Cut 5 D2235-3 FROM D3166-1 using DT8365 ✓
 2-Cut Ribs from 3/4" x 3/4" x 0.065 wall 304/316 SS tubing as per dwg. ✓
 3-Remove all markings from material ✓
 4-Drill holes in D3053-3 as per dwg D3053 ✓
 5-Drill holes in three D2235-3 ribs as per dwg D3053 using DT8995 ✓
 6- Cut mesh as per dwg ✓

1x **DAS 43 9-89** JAN 21 2015

110 Weld per dwg A/R S.S. rod Batch: M130264 0.00
110
 Large Fab Memo 0.00
 Large Fab 1 -Weld as per Dwg D3053 using Welding Table and corner Jig Deburr as required

DAS 43 9-89 FEB 09 2015
① 15-02-09

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube ☐</td> <td>Crosstube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00				①	15-02-09.		DAS 9 9-89
130 *130* QC Quality Control	QC6- Inspect dimensions to drawing Memo	0.00 0.00				①	15-02-09.		DAS 9 9-89
150 *150* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M. 129808</i> Memo START TIME: <i>1:40</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:10</i>	0.00 0.00					<i>1</i> <i>15-2-9</i>		DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							UAS 38 9-89
160									
QC	Memo	0.00							
Quality Control									FEB 10 2015
170	Identify as per dwg & Stock Location: <u>WLO</u>	0.00							
170									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									

Handwritten: 13127658 1x of JEL 150210
 15-02-10

DQA: _____ Date: _____



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FAULT CATEGORY

Landing Gear ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Marks/Chatter ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drawing ☐ Drill Holes ☐ Finish ☐ Fit/Function	☐ Folio/Program ☐ Grain ☐ Hardware ☐ Inspection Incomplete/Unqualified ☐ Instructions Incomplete/Unclear ☐ Misaligned/off center ☐ Mislabeled ☐ Misread ☐ Off-set ☐ Out of Calibration ☐ Out of Sequence	☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Set-up ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other
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Picklist Print

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Work Order ID: 127525

127525

Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 1/06/15

Required Date: 1/06/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP C02.09.04M304EX0.75-16F was M750-16FXS-S/SKJ/RF
IPP Rev:D 08-08-29 revB as per dwg DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D2232-3		Manufactured	No			110	Each	44.0000	2	2			
✓ *D2232-3*									**			DAS 43 9-89	JAN 22 2015
Basket Hinge													

Location	Loc Qty	Loc Code
WA004	44	
101778	20	
105884	4	
115847	20	

B 101778 → 2x

D2327-3		Manufactured	No			110	Each	60.0000	2	2			
✓ *D2327-3*									**			DAS 43 9-89	JAN 22 2015
Spacer Bushing													

Location	Loc Qty	Loc Code
WA004	60	
100523	25	
103679	35	

B 103679 → 2x

D2581		Manufactured	No			110	Each	98.0000	2	2			
✓ *D2581*									**			DAS 43 9-89	JAN 22 2015
Mounting Bracket													

Location	Loc Qty	Loc Code
WA004	98	
102265	58	
122730	40	

B 102265 → 2x

DQA: _____ Date: _____



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Picklist Print

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Parent Item: D3053-042

D3053-042

Parent Item Name: 212 Basket Base Assembly

Start Date: 1/06/15

Required Date: 1/06/15

Start Qty: 1.00

Required Qty: 1.00

✓ D3166-1 Manufactured No

100 Each 18.0000 5 5

D3166-1

Basket Hoop

DAS
43
9-89

JAN 22 2015

B125268 → 5x

Location

Loc Qty

Loc Code

WA004 18
125268 18

✓ M304EX0.75-16F Purchased No

100 sf 808.0000 48 51

M304FX0 75-16F

Expanded Metal Flat SS

DAS
43
9-89

JAN 22 2015

M131107 → 60 Oct

Location

Loc Qty

Loc Code

WA006 808
M129716 52
M130464 116
M131107 640

✓ M304TS0.750W.065 Purchased No

100 f 860.5000 43.3333 46

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

DAS
43
9-89

JAN 22 2015

B128495 → 750f

Location

Loc Qty

Loc Code

WA004 860.5
125513 53.5
m126538 215
m128495 592

DQA: _____ Date: _____



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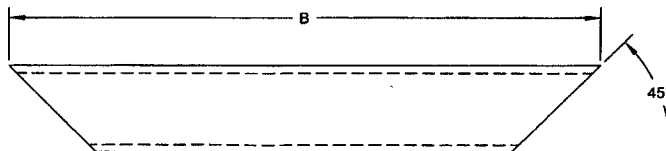
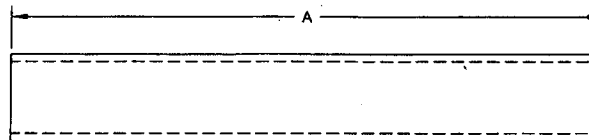
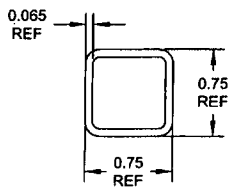
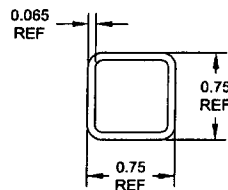
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		☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge
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QTY -041	QTY -042	PART NO	LENGTH A	LENGTH B	DESCRIPTION
X		D3053-041	N/A	N/A	BASKET BASE ASSY
	X	D3053-042	N/A	N/A	BASKET BASE ASSY
2	2	D3053-1		96.00	RIB
2	2	D3053-3		25.50	RIB
6	6	D3053-5	23.73		RIB
3	3	D3053-7	25.31		RIB
3	3	D3053-9	19.48	N/A	RIB
2	2	D2327-3	N/A	N/A	BUSHING
2	2	D2581	N/A	N/A	MOUNTING BRACKET
2	2	D2232-3	N/A	N/A	HINGE PLATE
5	5	D2235-3	N/A	N/A	RIB



D3053-X RIB

NOTES:

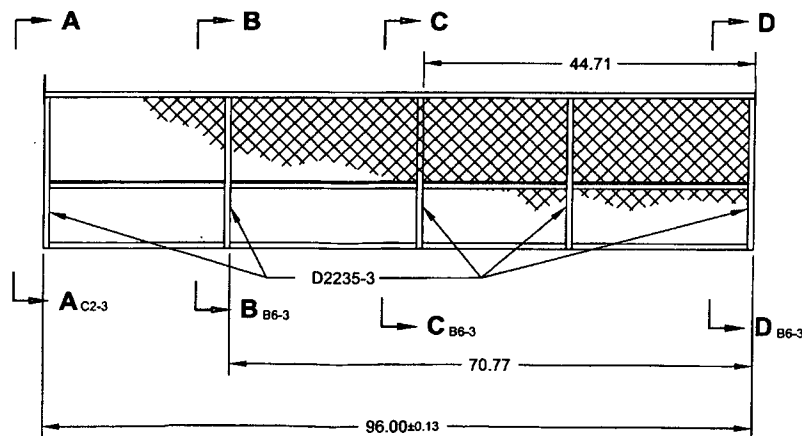
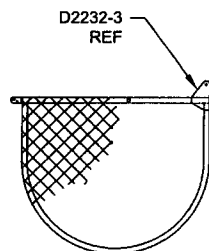
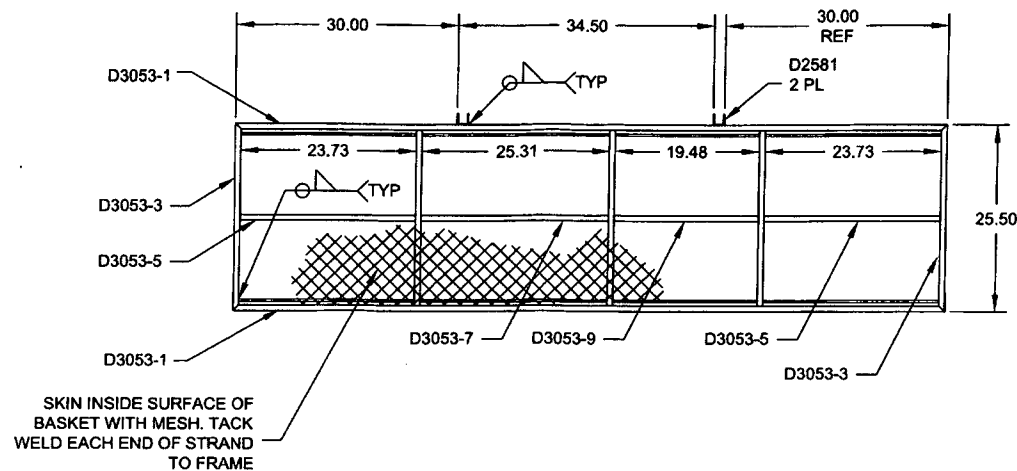
- 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING
REF. DART SPEC M304TS0.750W.065
- 2) MESH MATERIAL: 3/4-16F EXPANDED SS
REF DART SPEC M304EX0.75-16F
- 3) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: N/A
- 9) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 10) WELD PER DART QSI 004

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INVENTORY
ORDER

127525 MJS

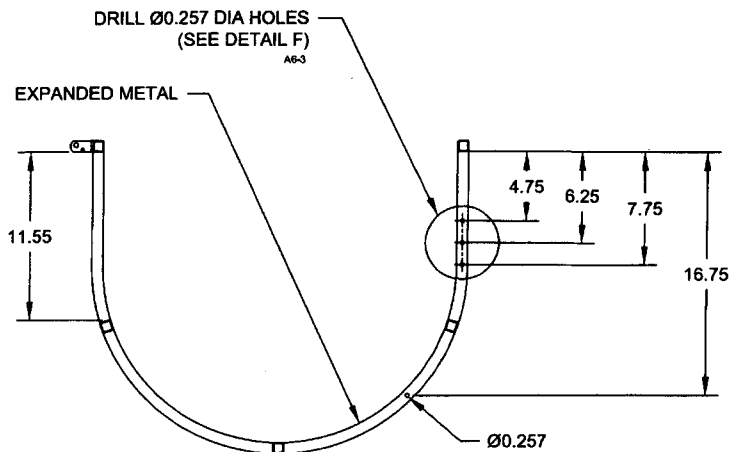
14-12-22

C	ADD -041 VIEWS, ZN B4-2, D4-2, B7-2. RE-ORGANIZE DWG. REF NCR13-2766.	DC	13.12.12
B	FRAME MATERIAL WAS 0.060 WALL. MESH MATERIAL UPDATED. DRAWING MOVED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS.	AJS	08.07.02
A	NEW ISSUE	RF	01.11.01
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 1 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
DATE	13.12.12	COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

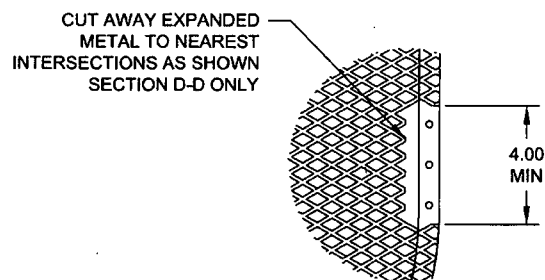


D3053-041 BASKET BASE ASSEMBLY

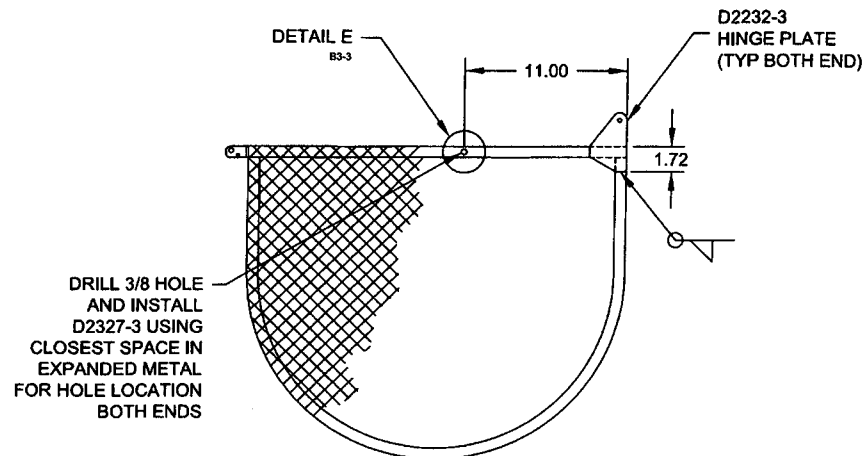
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DRAWN	DC	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. REV. C
MFG. APPR.	DD	D3053 SHEET 2 OF 5
APPROVED	HS	TITLE SCALE
DE APPR.		BASKET BASE ASSEMBLY (212) NTS
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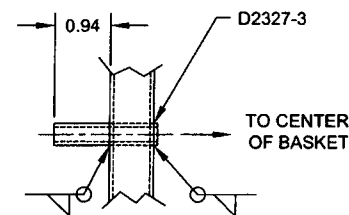
SECTION B-B
SECTION C-C
AND SECTION D-D
RIB DETAIL



DETAIL F
SCALE NONE



SECTION A-A
SPACER DETAIL

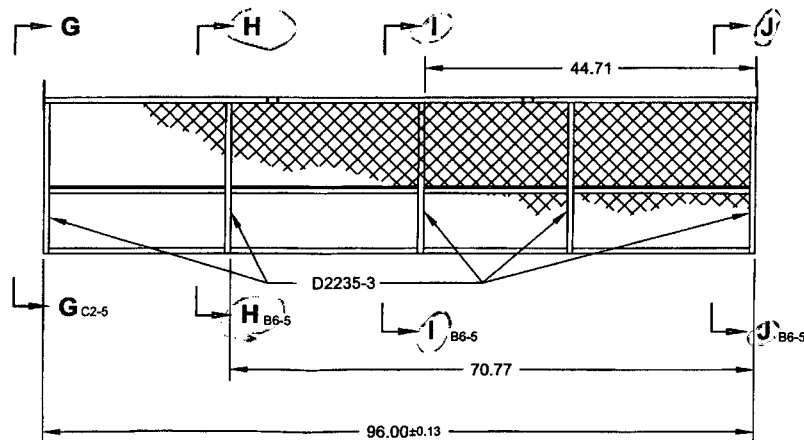
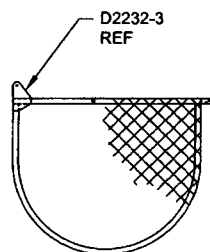
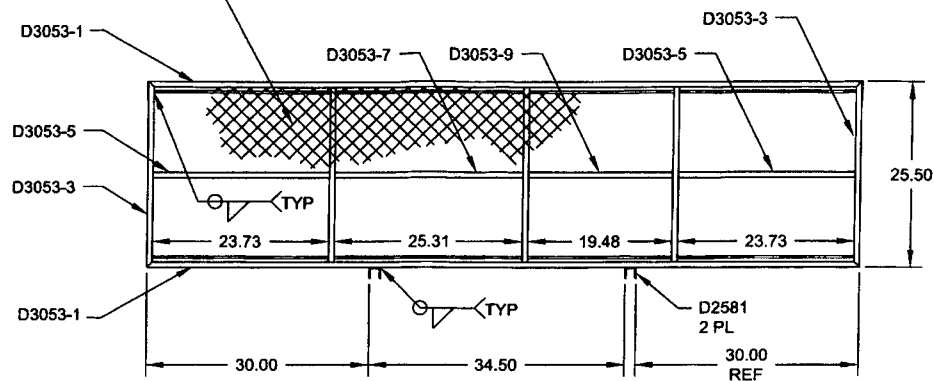


DETAIL E
SCALE 4X

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DC		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 3 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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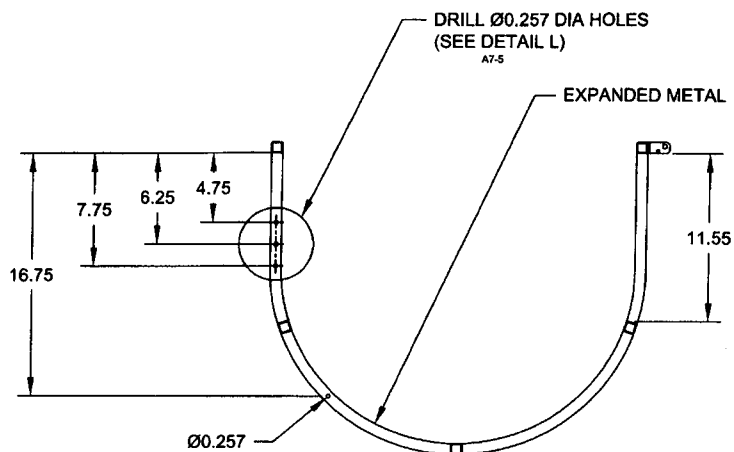
RELEASED
2014-01-03

SKIN INSIDE SURFACE OF
BASKET WITH MESH. TACK
WELD EACH END OF STRAND
TO FRAME

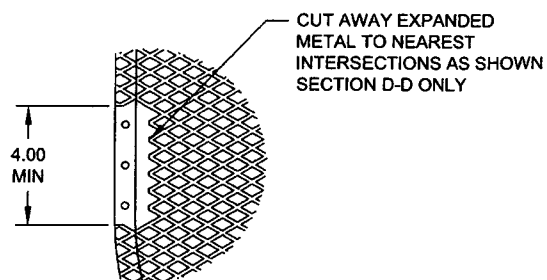


D3053-042 BASKET BASE ASSEMBLY SHOWN

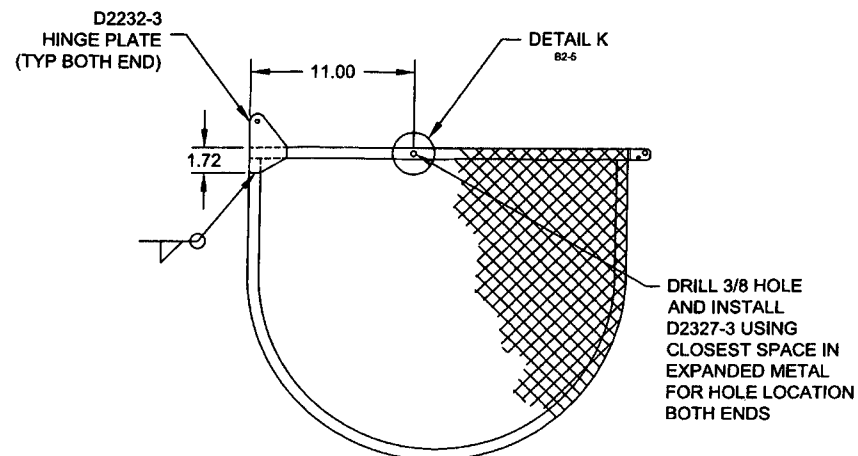
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DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 4 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.	HS	BASKET BASE ASSEMBLY (212)	NTS
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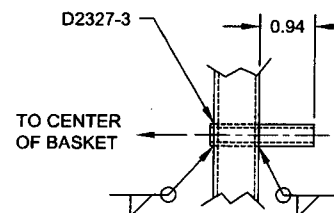
SECTION H-H
SECTION I-I
AND SECTION J-J
RIB DETAIL



DETAIL L
SCALE NONE
C7-5



SECTION G-G
SPACER DETAIL



DETAIL K
SCALE 4X
D3-5

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	DD	D3053	SHEET 5 OF 5
APPROVED	HS	TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (212)	NTS
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